

Date: Wednesday, 3/21/2007 3:49:01 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 31427	
Estimate Number : 10709	
P.O. Number : N/A	Part Number : D32101
This Issue : 3/21/2007 S.O. No. : N/A	Drawing Number : D3210 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 30898	Material : N/A
Written By : _____	Due Date : 4/4/2007 Qty: 10 Um: Each
Checked & Approved By : <u>07.03.22</u>	
Comment : Est Rev:A New Issue 05-11-17 JLM	
Est Rev:B Now On Waterjet 06-10-24 JLM	

Additional Product



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



Comment: Qty.: 2.6177 sf(s)/Unit Total : 26.1765 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick M18481
(M2024T3S.080)Identify as D3210-1
Batch: M102838 ml 07 04 03

(10)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3210
Dwg Rev: A ml 07 04 04
Prog Rev: A

(10)

2-Deburr if necessary

07/04/10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

2024.07 (10)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

80 07/04/10

(10)

5.1

QC5 Inspect work.

2024.04.11 (10)

(PTD)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	
070411	5.1	Add QCS to inspect work → deburring perm. change <i>[Signature]</i>				<i>[Signature]</i> 070411	<i>[Signature]</i> 070411	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 07/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

82

07-04-12

10

7.0

POWDER COATING

POWDER COATING



M102361



10X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-k

07/04/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/4/13 59

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/16

Job Completion



u 07-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	W	DRAWN BY	W	DART AEROSPACE LTD
CHECKED	H	APPROVED	H	HAWKESBURY, ONTARIO, CANADA
DATE	03.09.03	DRAWING NO.	D3210	REV. A
		TITLE	DOUBLER	SHEET 1 OF 1
				SCALE
A		03.09.03	NEW ISSUE	1:3

D3210-1 DOUBLER
MAKE PER DRAWING FILE "D3210-A1.DWG"
CHECK PER TEMPLATE D3210-1T1
DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER
DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

DETAIL A
SCALE 2:3

